

Work Order ID 161366

Friday, May 12, 2017 4:40:08 PM

161366

Page 1

Item ID: 647.7810 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket A
 Start Date: 5/15/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/9/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference: (P.A.)SCHEDULED/U

Approvals: Process Plan: PA DAS Date: 2017/05/15 Tooling: _____ Date: _____
 QC: 21 9-85 Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.7800	A

100
100
 Bandsaw
 Jeaspa Bandsaw
 BAND SAW
 Memo
 Cut Blank at 10.313"
 0.00
 0.13
 2 0 mf
 17/05/18

110
110
 HAAS 1
 HAAS CNC vertical machine #1
 HAAS CNC VERTICAL MACHINING #1
 Memo
 1-Machine per folio FB408
 DWG REV: A
 FOLIO REV: AD
 0.34
 0.76
 2- deburr and break all sharp edges
 2 P17-05-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 161366

161366

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Friday, May 12, 2017 4:40:08 PM

Item ID: 647.7810 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bracket A
Start Date: 5/15/2017 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 6/9/2017 Req'd Qty: 2.00 *2* Customer:
Reference: (P.A.)SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.20				2	0		17-05-18
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.40				2	0		DAS 14 9-89 17/05/18
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : 36583 1- Black Anodize as per Dwg 647.7800 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	0.00 360.00				2		JUN 06 2017	DAS 13 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER :							
Misidentified	☐	Past Due								

Work Order ID 161366

161366

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Friday, May 12, 2017 4:40:08 PM

Item ID: 647.7810 Accept ***N900040100*** Setup Start ***NS1***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.04							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.40							
Quality Control	1.5 mils thickness primer								
180	Identify as per dwg & Stock Location CE-D71A	0.00							
180									
Packaging	Memo	0.02							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								

2x 5017-6-16

2 68-6 8C JUN 19 2017

2 JUN 20 2017 DAS 6 8-88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 161366***161366***

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Friday, May 12, 2017 4:40:08 PM

Item ID: 647.7810 Accept ***N900040100*** Setup Start ***NS1***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21 - Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.20							
Quality Control									

68-6
12
DAS

JUN 2 0 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
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Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Friday, May 12, 2017 4:40:08 PM

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Work Order ID: 161366

161366

Parent Item: 647.7810

647 7810

Parent Item Name: Bracket A

Start Date: 5/15/2017

Required Date: 6/9/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A RQ 15.08.06 Verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B6.000X0.250		Purchased		No		100	f	24.7490	0.859	1.808421			

M7075T6B6 000X0 250

**

7075-T6 BAR 6.000" X 0.250"

Location	Loc Qty	Loc Code
MAT005	24.749	
M133426	3.083	
M136103	2.699	
→ M136839	6.967	
M137090	12	

1.81

MK 2017-05-18
ML

170515

Please see Pablo's attach
Email for material approval.

DQA: _____ Date: _____



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Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																	
OTHER : _____																																																																				

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	17-05-18	Date:	17/05/18	Date:	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
NC	LAST PROTOTYPE RELEASE PPD		NC
NC	INITIAL RELEASE	12-21-01	P. BRAVO
A	INCORPORATED ECH 82128, 04487, & 04528	03-02-16	P. BRAVO

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH IAW MPP-172 SECTION 3.3 & 4.3.
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1161 360

PA 2017/05/15

	647.7823	CROSS BRACKET AFT	△	△
	647.7822	EYE BOLT FITTING RH	△	△
	647.7821	EYE BOLT FITTING LH	△	△
	647.7820	CROSS BRACKET AFT	△	△
	647.7819	CROSS BRACKET FWD	△	△
	647.7818	MOUNTING CHANNEL	△	△
	647.7817	AFT BRACKET	△	△
	647.7816	AFT BRACKET	△	△
	647.7815	FORWARD BRACKET	△	△
	647.7814	FORWARD BRACKET	△	△
	647.7813	CENTER PLATE LOWER	△	△
	647.7812	CENTER PLATE UPPER	△	△
	647.7811	BRACKET B	△	△
	647.7810	BRACKET A	△	△
F/N	PART #	DESCRIPTION	MAT'L	SPEC
QTY	PARTS LIST			
NEXT ASSY (S)	ORIGINAL DATE 2002-04-15	100029	DART 3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300 APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
647.7300	DRAWN BY	ENGINEER		
	1. APPROVED BY	P. BRAVO		
	DRAWING APPROVAL	P. BRAVO		
	02/2/02			
	CONTRACT No.		BRACKET	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES DECIMALS ±.01 3 PLACES DECIMALS ±.005 ANGLES ±.5°			REV. 8 CAUSE CODE 07M26 DWG. NO. 647.7800 REV. A	
			SCALE NONE SHEET 1 OF 10	

DQA: _____ Date: _____



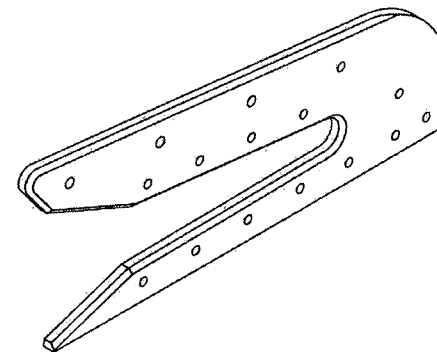
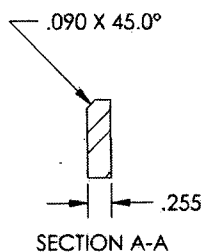
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

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647.7810
647.7811 OPPOSITE

TAG	X LOC	Y LOC	SIZE
A1	9.092±.002	3.332±.002	Ø .201 THRU
A2	6.906±.002	3.083±.002	Ø .201 THRU
A3	4.720	2.835±.002	Ø .201 THRU
B1	7.300±.002	.397±.002	Ø .177 THRU
B2	7.203±.002	2.349±.002	Ø .177 THRU
B3	6.050±.002	.415±.002	Ø .177 THRU
B4	5.961±.002	2.228±.002	Ø .177 THRU
B5	4.800±.002	.433±.002	Ø .177 THRU
B6	4.719±.002	2.088±.002	Ø .177 THRU
B7	3.550	.450	Ø .177 THRU
B8	3.476	1.947	Ø .177 THRU
B9	2.575	2.475	Ø .177 THRU
B10	2.380	.400	Ø .177 THRU
B11	1.250	.400	Ø .177 THRU
B12	1.160	1.220	Ø .177 THRU
B13	.500	.400	Ø .177 THRU

647.7810 SHOWN
647.7811 OPPOSITE

ORIGINAL DATE (MM/DD/YY) 11/25/09		DART 3030 ENTERPRISE CT., AEROSPACE SUITE A VISTA, CA 92081 (760) 724-5300 APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWN BY: J. CHEEPP E. ANDERSON P. BRAVO			
DRAWING APPROVAL P. BRAVO 10/21/09		BRACKET SEE CASE CODE DWS. NO. REV. B 07M26 647.7800 A SCALE NONE SHEET 2 OF 10	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
1 PLACE DECIMALS ± .010
2 PLACE DECIMALS ± .005
ANGLES ± .5°

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

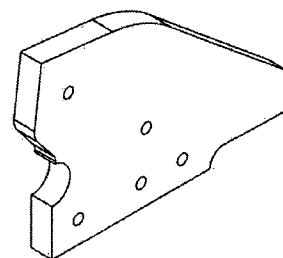
QA Closed: _____ Date: _____

Work Order update only ☐

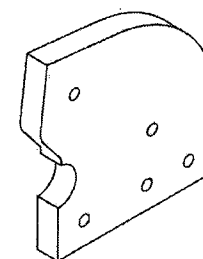
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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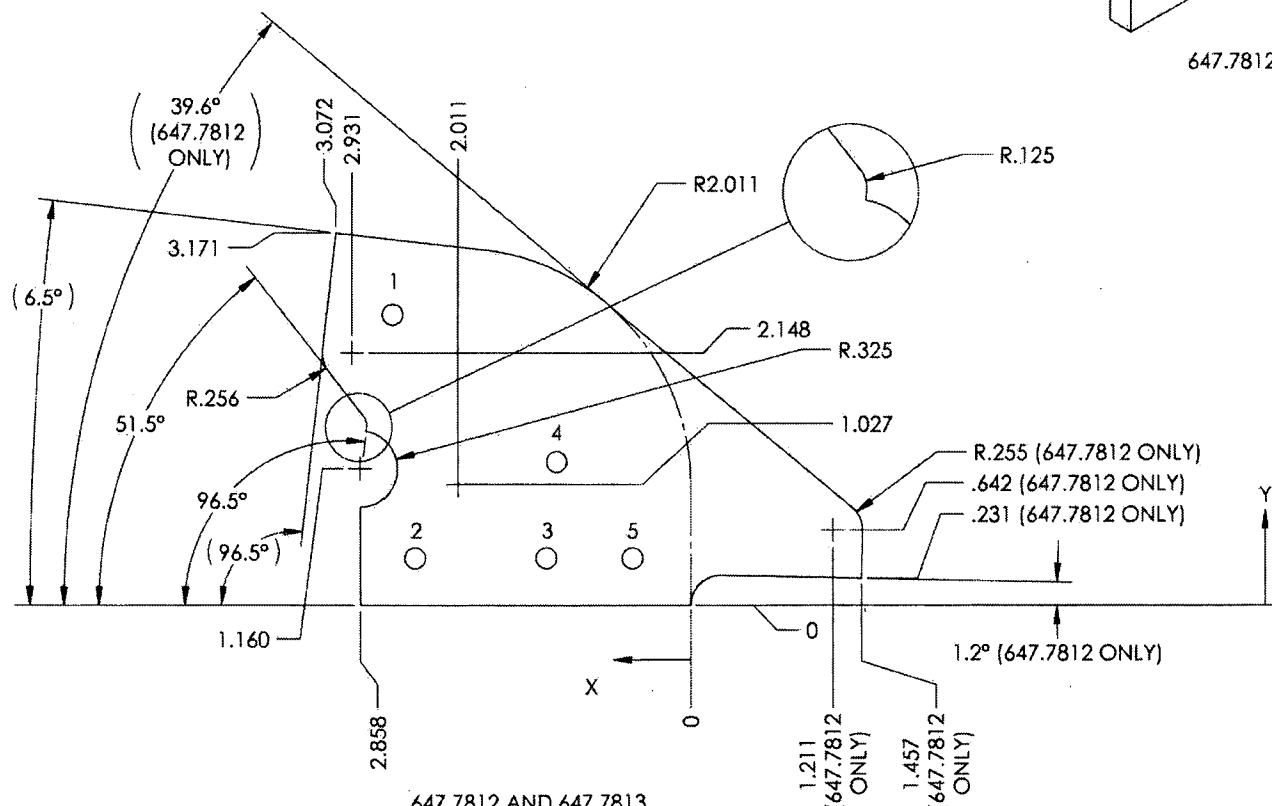
TAG	X LOC	Y LOC	SIZE
1	2.575±.002	2.475±.002	Ø.177 THRU
2	2.380±.002	.400±.002	Ø.177 THRU
3	1.250±.002	.400±.002	Ø.177 THRU
4	1.160±.002	1.220±.002	Ø.177 THRU
5	.500±.002	.400±.002	Ø.177 THRU



647.7812



647.7813



647.7812 AND 647.7813

ORIGINAL DATE 11/25/05		3030 ENTERPRISE CT., SUITE A	
DRAWN BY E. ANDERSON		VISTA, CA 92081	
CHECKED BY J. BRAY		(760)-724-5300	
DRAWING APPROVAL P. BRAY		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
CONTRACT NO.		BRACKET	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS .005 ANGLES .5°		SHEET CODE B 07M16	REV. A
SCALE NONE		SHEET 3 OF 10	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

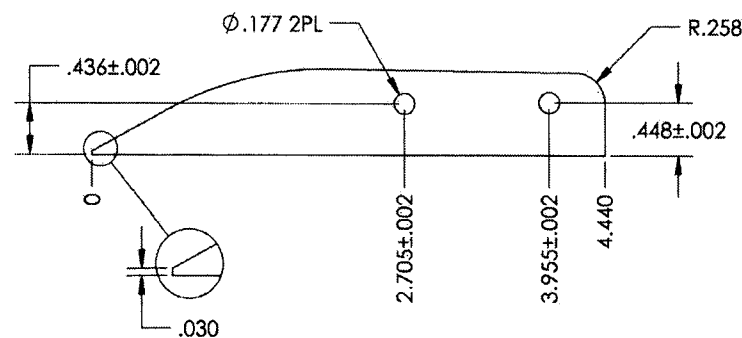
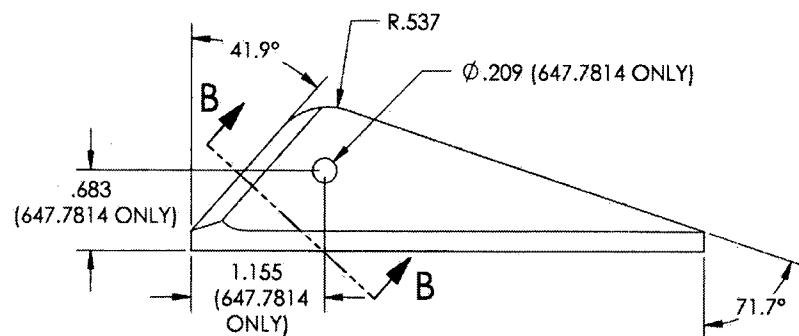
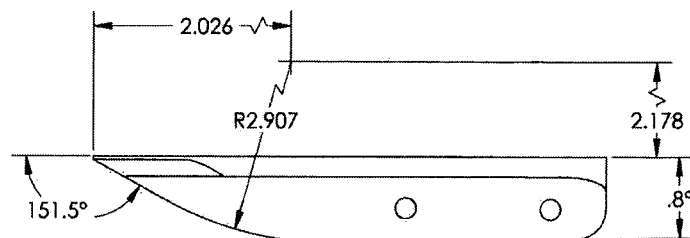


QA Closed: _____ Date: _____

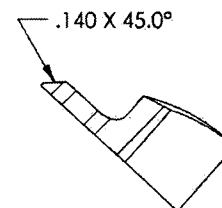
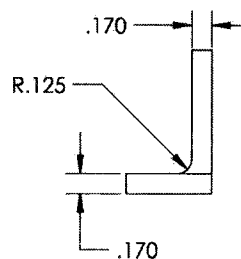
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				☐ OTHER : _____					

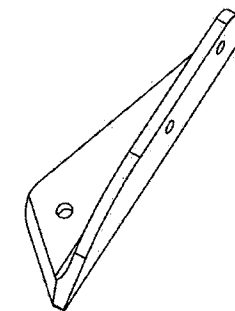
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.



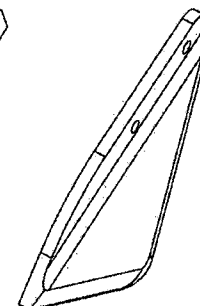
647.7814 SHOWN
647.7815 OPPOSITE



SECTION B-B



647.7814



647.7815

ORIGINAL DATE: 11-02-09 DIMO DATE: 11-02-09 DRAWN BY: E. ANDERSON CHECKED BY: P. SHAY DRAWING APPROVAL: P. SHAY CONTRACT NO.:		DART 3030 ENTERPRISE CT., SUITE A AEROSPACE VISTA, CA 92081 APICAL INDUSTRIES, INC. (760) 724-5300 DBA DART AEROSPACE	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		BRACKET SHEET 4 OF 10	
SGT B	CAGE CODE 07M26	DWG. NO. 647.7800	REV. A
SCALE: NONE		SHEET 4 OF 10	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

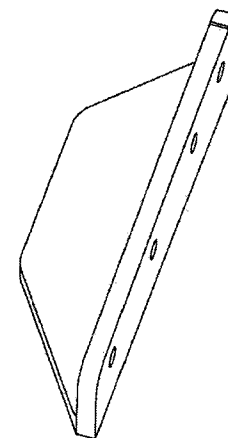
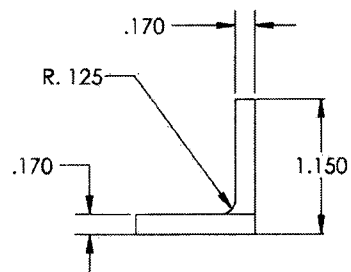
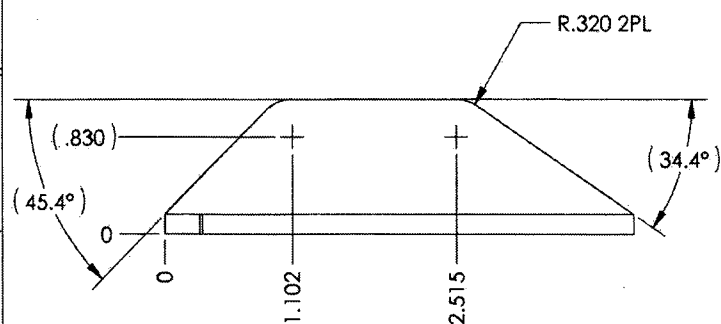
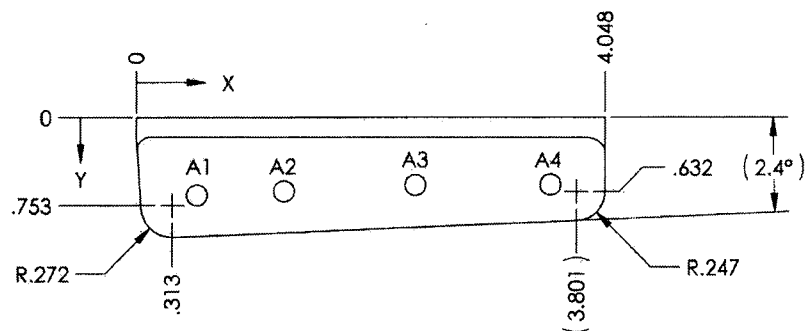
QA Closed: _____ Date: _____

Work Order update only ☐

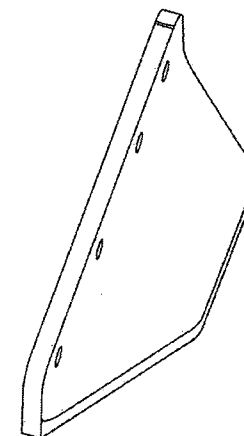
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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TAG	X LOC	Y LOC	SIZE
A1	.527±.002	.666±.002	Ø.177 THRU
A2	1.276±.002	.631±.002	Ø.177 THRU
A3	2.404±.002	.578±.002	Ø.177 THRU
A4	3.576±.002	.573±.002	Ø.177 THRU



647.7816



647.7817

647.7816 SHOWN
647.7817 OPPOSITE

ORIGINAL DATE 11-28-07	DART AEROSPACE 3030 ENTERPRISE CT., SUITE A VISTA, CA, 92081 (760)-724-5300	
DRAWN BY E. ANDERSON	CHECKED P. BRAY	APICAL INDUSTRIES, INC. DBA DART AEROSPACE
DRAWING APPROVAL P. BRAY	BRACKET	
CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		
REV. (CAGE CODE)	DWG. NO.	REV.
8 07/02/15	647.7800	A
SCALE: NONE		SHEET 5 OF 10

DQA: _____ Date: _____



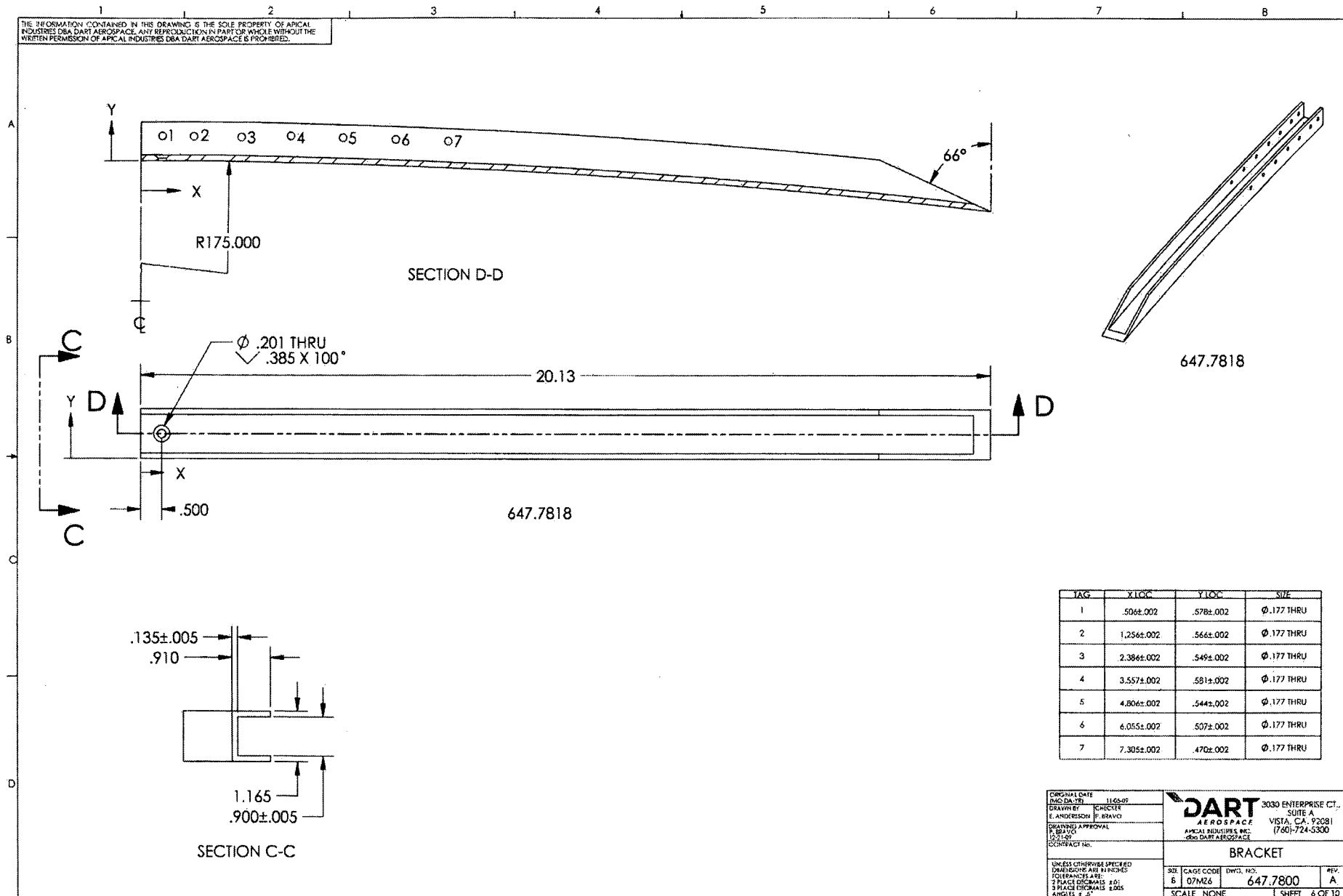
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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DQA: _____ Date: _____



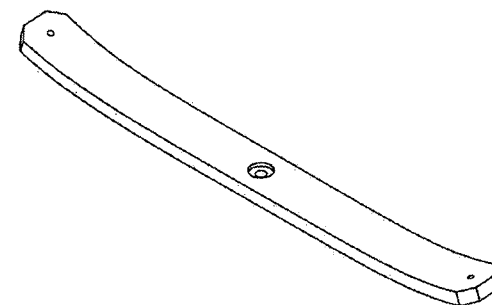
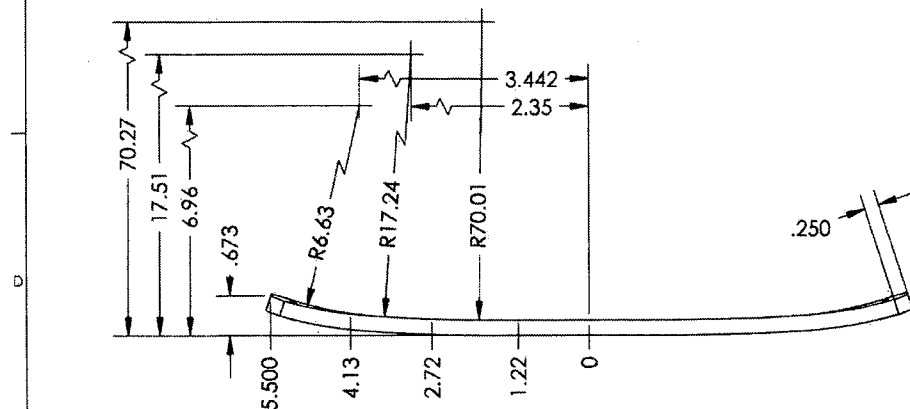
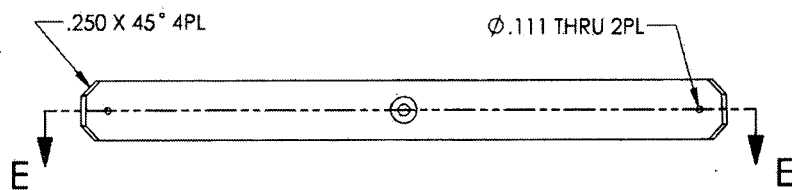
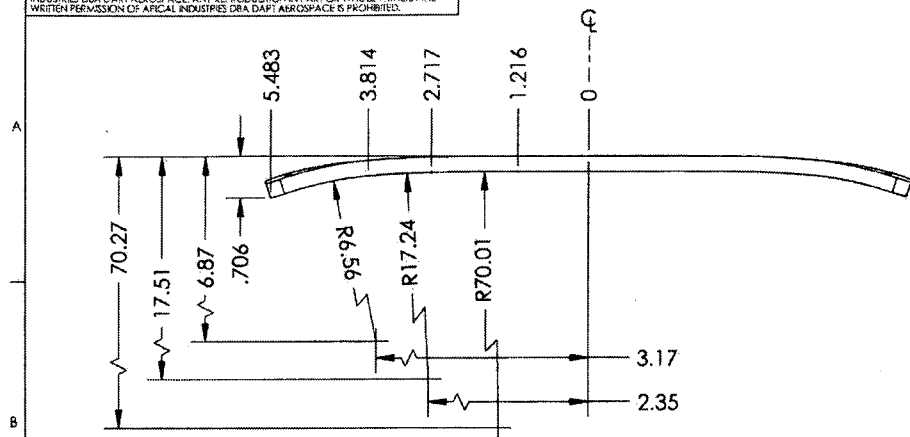
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

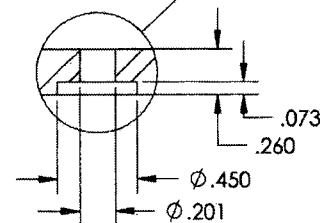
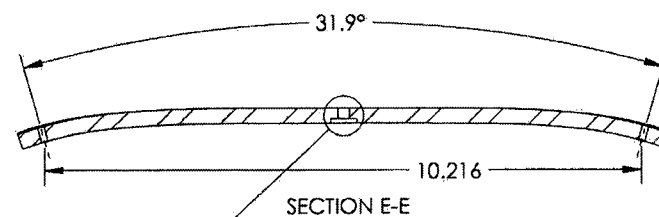
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

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647.7819



ORIGINAL DATE 11-05-89		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY E. ANDERSON	CHECKED BY F. BRAY	DART AEROSPACE APICAL INDUSTRIES, INC. (DBA DART AEROSPACE)	
DRAWING APPROVAL P. BRAY		BRACKET	
CONTRACT NO.		REV. B	REV. A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.001 ANGLES ±.5°		SCALE NONE	SHEET 7 OF 10
CASE CODE B 07ALZ		DWG. NO. 647.7800	

DQA: _____ Date: _____



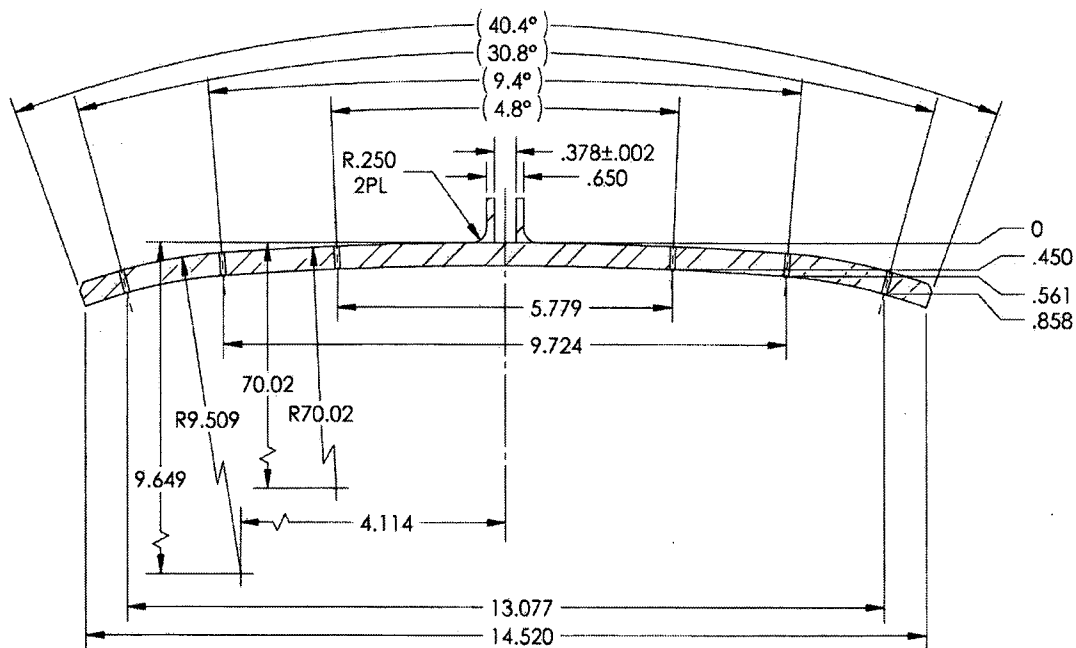
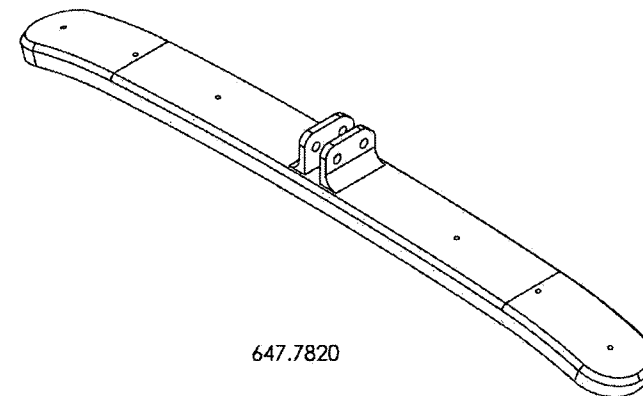
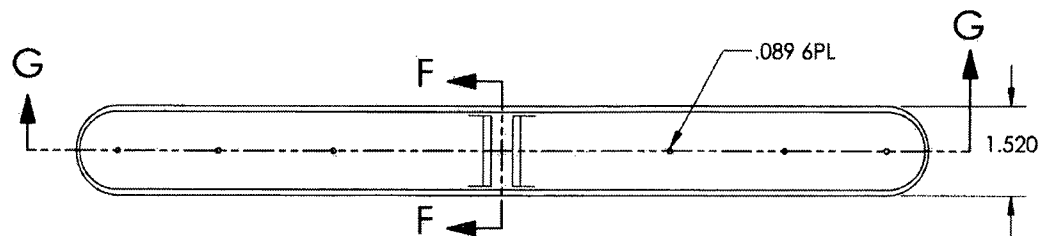
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

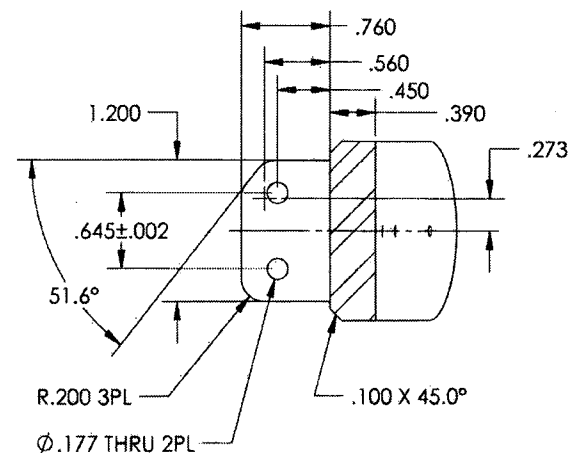
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
									QC / QA Coordinator Approval																
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐																		

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SECTION G-G



SECTION F-F

ORIGINAL DATE: 11/20/09	DART AEROSPACE 3030 ENTERPRISE CT., SUITE A, VISTA, CA 92081 (760) 724-5300		
DRAWN BY: E. ANDERSON	CHECKED BY: P. BRAVO		
DRAWING APPROVAL: P. BRAVO	APICAL INDUSTRIES, INC. DBA DART AEROSPACE		
CONTRACT NO.	BRACKET		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE 1/100 2 PLACE DECIMALS 1/1000 ANGLES ± .5°	SEE: CAGE CODE B 071426	DWG. NO. 647.7800	REV. A
SCALE: NONE		SHEET 8 OF 10	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

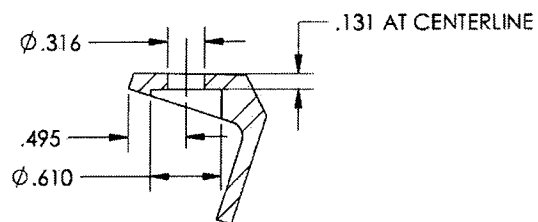
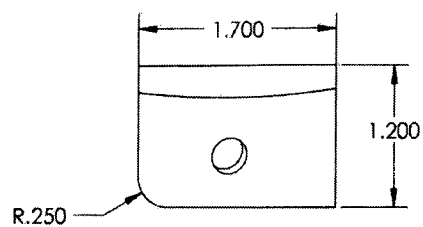


QA Closed: _____ Date: _____

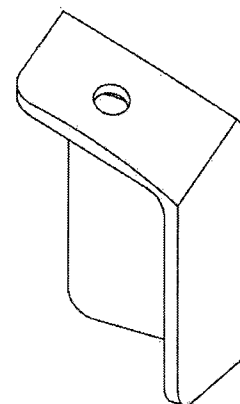
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

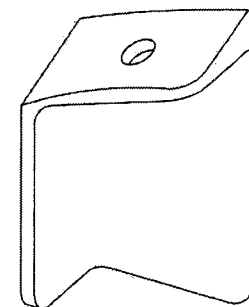
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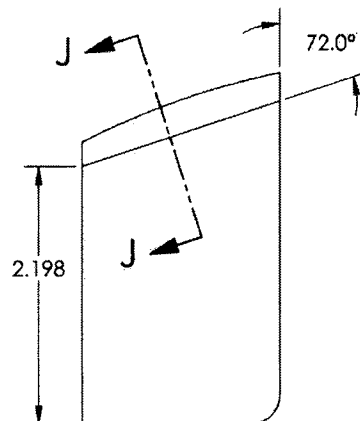
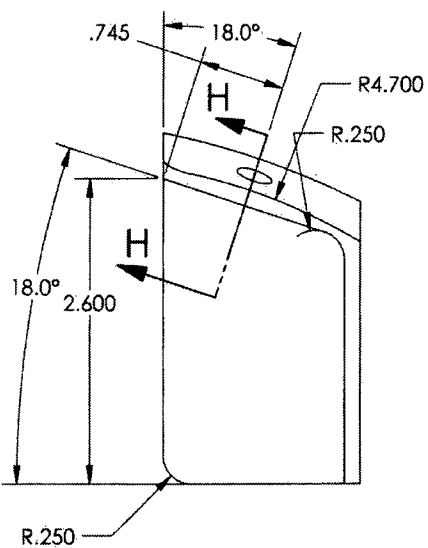
SECTION H-H



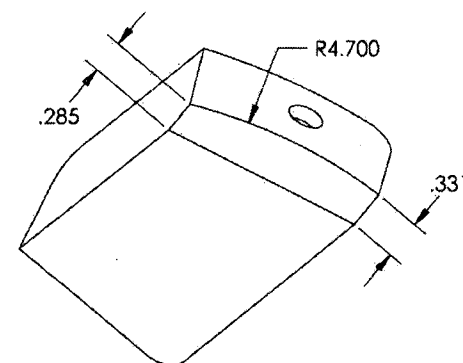
647.7821



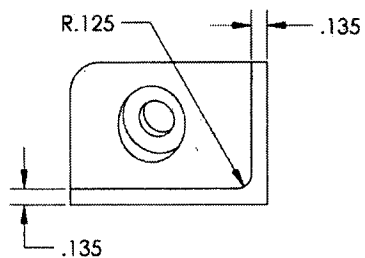
647.7822



SECTION J-J



SECTION K-K



647.7821 SHOWN
647.7822 OPPOSITE

ORIGINAL DATE 11-06-00	3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300
DRAWN BY E. ANDERSON	APICAL INDUSTRIES, INC. DBA DART AEROSPACE
DESIGNED BY P. BRAVO	
DRAWING APPROVAL P. BRAVO	
CHECKED BY J. B. BROWN	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES 1/16 0.0015 1/16 0.0015 1/16 0.0015	
SHEET 1 OF 10	DWG. NO. 647.7800 REV. A
SCALE: NONE	1 SHEET 9 OF 10

DQA: _____ Date: _____

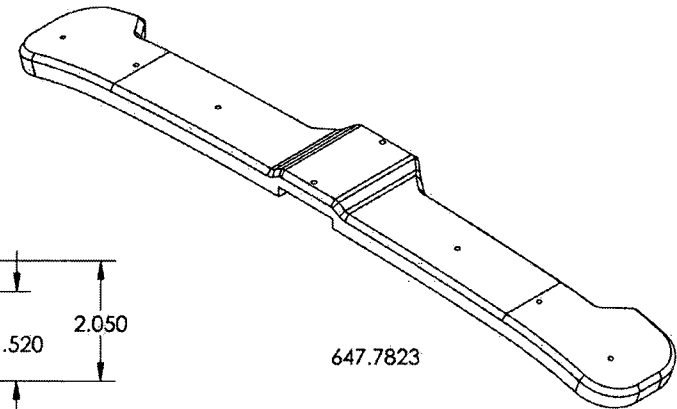
**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

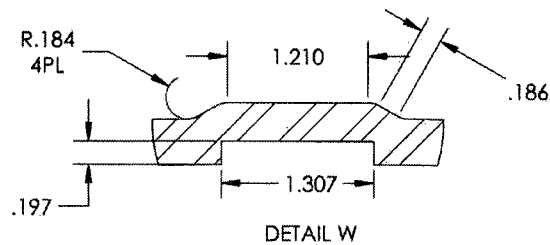
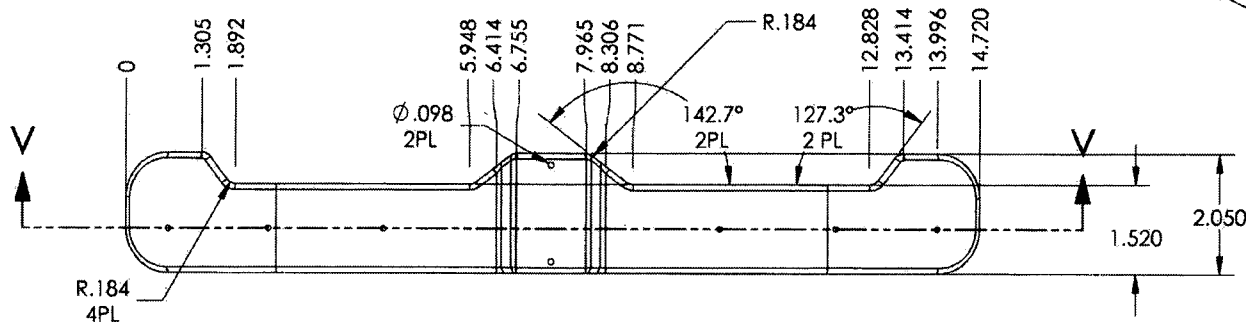
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

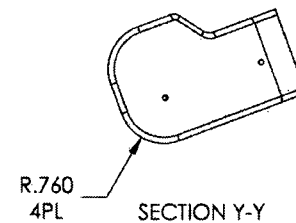
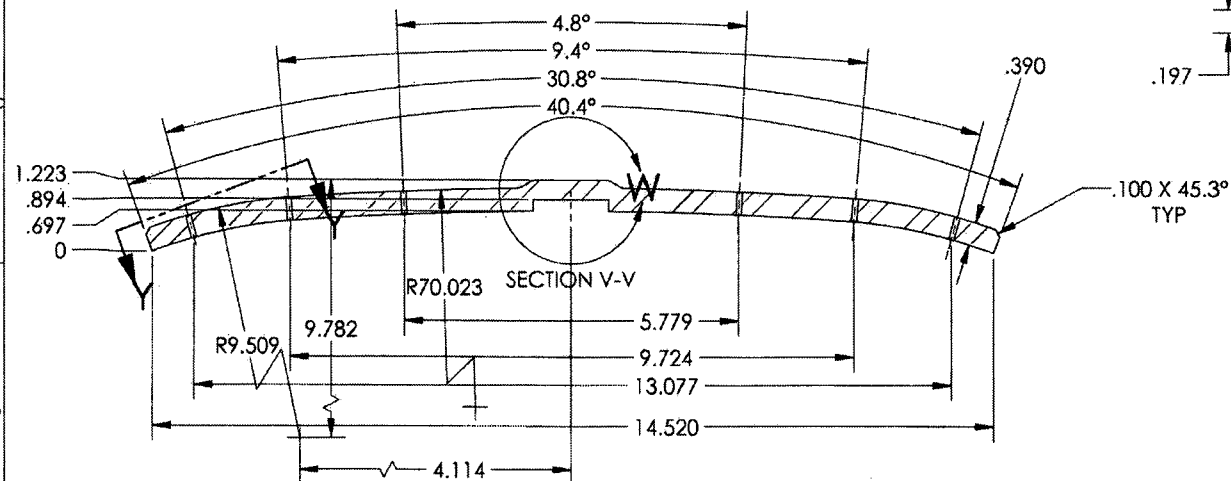
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.



647.7823



DETAIL W



R.760
4PL

SECTION Y-Y

ORIGINAL DATE (MAY 2018)		11-05-09	
DRAWN BY E. ANDERSON		CHECKED BY J. BRAY	
DRAWING APPROVAL P. BRAY		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°			
SHEET B	CAGE CODE 07MZ6	DWG. NO. 647.7800	REV. A
SCALE NONE		SHEET 10 OF 10	

DART 3030 ENTERPRISE CT., SUITE A
 AEROSPACE VISTA, CA 92081
 ATICAL INDUSTRIES INC (760) 724-5300
 DBA DART AEROSPACE

BRACKET

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : _____																																																																				

David Duval

From: Chantal Lavoie
Sent: May-05-17 1:53 PM
To: David Duval
Subject: FW: 17814
Attachments: M7075T6B-RevB.pdf; 646.3000 NC1 Lower Cutter Assy [ECN 02195].pdf; D4842-RevB.pdf

Follow Up Flag: Follow up
Flag Status: Flagged

From: Chantal Lavoie
Sent: Tuesday, May 02, 2017 11:57 AM
To: 'Eric Downing' <edowning@dartaero.com>
Subject: FW: 17814

Hi Eric,
Check this e-mail, for 7075-t6 bar or cut from plate.
Thanks
Chantal

From: Chantal Lavoie
Sent: Tuesday, May 10, 2016 1:20 PM
To: Chris Provencal <cprovencal@dartaero.com>
Cc: 'Eric Downing' <edowning@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: FW: 17814

Hi Chris,
I found another problem when ordering material, see attached for mill spec's 7075-T6.
Material spec's call out 7075-T6/T651 etc..... But with no indication of AMS or QQ-A accepting T651.
Please advise if you can sign deviation would need to order some material.

Note: this material is used for cable cutter part if you look at dwg from Apical (646.3000) they call out 7075-T651 under AMS-QQ-A-250/12, see attached for dwg files.

Dart dwg (D4842) only call out 7075-t6 see attached for dwg files. 95% of 7075-T6 material will be under 7075-T651/AMS-QQ-A-250/12.

Thanks
Chantal

From: Linda Lacelle
Sent: Tuesday, May 10, 2016 1:02 PM
To: Chantal Lavoie <clavoie@dartaero.com>
Subject: FW: 17814

From: Pablo Bravo [<mailto:pbravo@apicalindustries.com>]
Sent: Friday, September 21, 2012 11:08 AM
To: 'Jean-Luc Menard' <jmenard@dartaero.com>; 'Linda Lacelle' <llacelle@dartaero.com>; 'David Shepherd' <dshepherd@dartaero.com>; 'Mike Petsche' <mpetsche@dartaero.com>
Cc: 'Isam El-Kassis' <ielkassis@dartaero.com>; 'Chantal' <clavoie@dartaero.com>; 'Bill Beckett' <bbeckett@dartaero.com>; 'Steve Joseph' <sjoseph@apicalindustries.com>
Subject: RE: 17814

After looking at this more closely, we should be able to use the AMS-QQ-A-250/12 that was originally quoted. No objection on this side to the material change. Let me know what documentation you need to make this happen.

Thanks,

Pablo

From: Jean-Luc Menard [<mailto:jmenard@dartaero.com>]
Sent: Friday, September 14, 2012 5:30 AM
To: 'Linda Lacelle'; 'David Shepherd'; 'Mike Petsche'
Cc: 'Isam El-Kassis'; 'Chantal'; 'Bill Beckett'; 'Pablo Bravo'; 'Steve Joseph'
Subject: RE: 17814

THE 1.250" x 2.00 " would be used on the rail 647.0200.
JL

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: Friday, September 14, 2012 7:59 AM
To: 'David Shepherd'; 'Mike Petsche'
Cc: 'Isam El-Kassis'; 'JEANLUC MENARD'; 'Chantal'; 'Bill Beckett'; 'Pablo Bravo'; 'Steve Joseph'
Subject: RE: 17814

JL will get the info on what part it is used in, as the boms are not made yet.
LL

From: David Shepherd [<mailto:dshepherd@dartaero.com>]
Sent: September-14-12 8:12 AM
To: 'Linda Lacelle'; 'Mike Petsche'
Cc: 'Isam El-Kassis'; 'JEANLUC MENARD'; 'Chantal'; 'Bill Beckett'; 'Pablo Bravo'; 'Steve Joseph'
Subject: RE: 17814

Linda,

My understanding is that Pablo Bravo will have to make ALL MRB decisions on the cable cutters since Apical owns the STC.

Therefore, you will need to send an email to Pablo to get a disposition on these types of issues.
What Apical p/n is this for?

PB,

Is the material substitution requested below acceptable?

If not, can you provide guidance on where you were purchasing this material so that Dart purchasing can track it down.

David

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: September-13-12 10:23 AM
To: 'Mike Petsche'
Cc: dshepherd@dartaero.com; 'Isam El-Kassis'; 'JEANLUC MENARD'; 'Chantal'
Subject: RE: 17814

Ok,so where do we go from here?

From: Mike Petsche [<mailto:mpetsche@dartaero.com>]
Sent: September-13-12 11:51 AM
To: Linda Lacelle
Cc: <dshepherd@dartaero.com>; Isam El-Kassis; JEANLUC MENARD; Chantal
Subject: Re: 17814

Cable cutters are largely outside of engineering. We are only manufacturing for apical. Using all apical data.

Sent from my iPhone

On 2012-09-13, at 11:40 AM, "Linda Lacelle" <llacelle@dartaero.com> wrote:

Any news on this pls?

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: September-11-12 12:57 PM
To: dshepherd@dartaero.com; 'Mike Petsche' (mpetsche@dartaero.com)
Cc: Isam El-Kassis (ielkassis@dartaero.com); JEANLUC MENARD (jmenard@dartaero.com)
Subject: FW: 17814
Importance: High

This is the mat'l for the cable cutters. All 7075 this big is cut from plate. So where do we go from here?

LL

From: Marc Bellavance [<mailto:mbellavance@dartaero.com>]
Sent: September-11-12 12:19 PM
To: 'Chantal Lavoie'
Cc: 'Lacelle, Linda'
Subject: RE: 17814

Chantal,

The mechanical properties of a 1.250" thick plate under AMS-QQ-A-250/11 are below the mechanical properties of a 1.250" thick bar under AMS-QQ-A-225/9 and AMS-QQ-A-200/11 so we can't accept to substitute as proposed below.

Marc Bellavance
Technical/Shop Support
T. 613-632-5200 | C. 613-
676-0992 | F. 613-632-
9311

1270 Aberdeen Street,
Hawkesbury, Ontario,
Canada, K6A 2K7

Product Documentation:
Verify Revision
Status/Download HERE!

<image001.jpg>

<image002.png> <image003.png> <image004.png> <image005.png>

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Please consider your environmental responsibility before printing this e-mail.

From: Chantal Lavoie [<mailto:clavoie@dartaero.com>]
Sent: Monday, September 10, 2012 2:39 PM
To: Marc Bellavance
Cc: Lacelle, Linda
Subject: FW: 17814

Hi Marc,
Please see attached for p/o:17814, material line 5 and 7 is spec's QQ-A-250-12 acceptable.
Thanks
Chantal

From: Ivers, Stan [<mailto:Stan.Ivers@thyssenkrupp.com>]
Sent: September 10, 2012 1:41 PM
To: 'Chantal Lavoie'
Subject: RE: 17814

Items 5-7 QQ-A- 250-12 is what was quoted please advise will order items 2-4

Thank you

Regards

Stan Ivers
Inside Sales Rep
ThyssenKrupp material NA
905-532-1350
30shi@tkmna.com

From: Chantal Lavoie [<mailto:clavoie@dartaero.com>]
Sent: Monday, September 10, 2012 12:31 PM
To: Ivers, Stan
Subject: RE: 17814

Sorry Stan,
I add send you this order last week please order.
Thanks
Chantal

From: Ivers, Stan [<mailto:Stan.Ivers@thyssenkrupp.com>]
Sent: September 10, 2012 8:07 AM
To: 'Chantal Lavoie'
Subject: 17814

Good morning Chantal

Please advise status on this p.o as nothing is on order and will miss delivery dates

Thanks

Regards

Stan Ivers
Inside Sales Rep
ThyssenKrupp material NA
905-532-1350
30shi@tkmna.com



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36583**

Purchase Order Date 6/6/2017

PO Print Date 6/12/2017

Page Number 3 of 5

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

5	161366	647.7810 BRACKET REV. A	6/16/2017	2.00	\$14.50	\$29.00
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Yes

6/16/2017

AS PER MPP-172 SECTION 2.1,
HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2
AS PER MPP-172 SECTION 4.2,
PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N

817-6-14

Line Total: \$29.00

6	161356	647.7811 BRACKET REV. A	6/16/2017	2.00	\$14.50	\$29.00
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Yes

6/16/2017

AS PER MPP-172 SECTION 2.1,
HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2
AS PER MPP-172 SECTION 4.2,
PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N

Line Total: \$29.00

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

6/12/2017

DAS
38
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913396

Date: 16-Jun-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 646.3814 Wiper Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21185	Rev: N/C PO: PO36583 Line: 1	
2 ea	Part: 647.7810 ✓ Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21189	Rev: A PO: PO36583 Line: 5	DAS 38 9-89 SP17-6-15
2 ea	Part: 647.7811 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21190	Rev: A PO: PO36583 Line: 6	
6 ea	Part: 647.7815 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21191	Rev: A FO: PO36583 Line: 7	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: _____ Made in Canada.			



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Terms

Ship Via

OUR TRUCK

Quantity

Description

Certified Signature: 15/04/2017

Receiver Signature: [Signature]

A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

SP17-6-15

Made in Canada.